

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015668**Date Inspected:** 18-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly Yard:

OBG Seg 9BW to Seg 9CW:

This QA Inspector observed the following work in progress:

The Submerged Arc Welding (SAW) process on weld joint no: OBW9-008. The welder was identified as 045270 and was observed welding in the 1G position. ZPMC Quality Control (QC) was identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with WPS: B-T-223(2)-1T-2. See attached photo for further details.

OBG Seg 9BW:

This QA Inspector observed the following work in progress:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: CA059-006. The welder was identified as

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045196 and was observed welding in the 4G position. ZPMC QC was identified as Wang Zhu. The welding variables recorded by QC appeared to comply with WPS: B-P-2214-TC-U4b-FCM-1.

The Flux Cored Arc Welding (FCAW) process on weld joint no's: SSD25-PP75-045, 046, 053, 054 061 and 062. The welder was identified as 207465 and was observed welding in the 3F position. ZPMC QC was identified as Wu Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-T-2133.

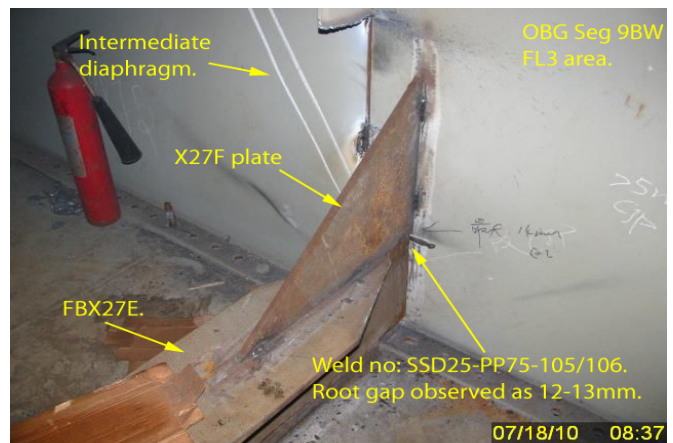
The FCAW process on weld joint no: SSD-PP75-104. The welder was identified as 207465 and was observed welding in the 2G position. ZPMC QC was identified as Wu Jin Long. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-B-U2-F.

During inprocess inspection, for weld no: SSD25-PP75-105/106, this QA Inspector observed that the root gap as 12-13mm. As per drawing, it is to be welded as a fillet weld. This QA Inspector discussed this issue with ZPMC QC, Mr. Wu Jin Long. It was understood that ZPMC will be welding this joint as a CJP weld. CT Engineer will be notified of this prior to welding. See attached photos for further details.

OBG Seg 9CE to Seg 9DE:

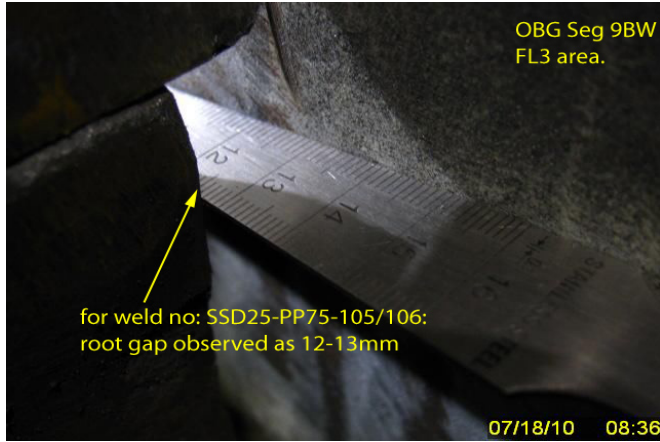
The FCAW process on weld joint no: SP374-001-044. The welder was identified as 067942 and was observed welding in the 3G position. ZPMC QC was identified as Liu Hua Jie. The welding variables recorded by QC appeared to comply with WPS: B-T-2233.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By:	Wadkar,Sailesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
